

Work Order ID 57076

Page 1

Saturday, March 20, 2010 9:50:55 AM

Item ID: D3915-041

Accept



Setup Start



Revision ID:

Item Name: Light Lid ass'y, Long lid

Stop



Start Date: 3/22/2010 Start Qty: 1.00



Cust Item ID:

PRELIMINARY ISSUE

Required Date: 3/31/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-3-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	Memo	0.00	10/04/01	14
D3915	PA/ Rev A M 10.04.01	Weld per dwg A/R Aluminum rod Batch: 4112860	0.00		
100		Large Fab			
Large Fab			0.00		
Large Fab		1- assemble ribs , weld as per dwg D3915 ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge, label plate and Mounting plates as per dwg D3915			
110	QC9- Inspect visual per QSI004- Fusion Welds	Memo	0.00	PD 10.04.01	
QC			0.00		
Quality Control					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O



QC

Quality Control

Memo

130

Chemical Conversion Coat per QSI005 4.1



HandFinish

Hand Finishing

Memo

0.00

0.00

8.0/04/02

checked to Reuse Day Rev A

140

Weld per dwg A/R Aluminum rod Batch: 0.00



Large Fab

Large Fab

Memo

m108436

0.00

I-weld (4) corners

m-f 10/04/02 (1x)

JPL 10-04-03

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo M118170.

0.00

1- touch up corner with alodine only
2- Plug holes prior to

1ST COAT:

START TIME: 8:00

OVEN TEMPERATURE: 320°

FINISH TIME: 8:00

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

BK 10-4-5 ♂
3 N/A ♀

P10→

W/O: 57076		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/01/01	150.1	ADD QC 6 to insert fit of L.D		10.01.01			S 16/04/12	

Part No: D3915-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Quality Control

88 12/04/05 (1) Ø

180

Assemble as per dwg

0.00



HandFinish

Hand Finishing

Memo

0.00

1- Install webbing as per dwg

J310/04/06 Ø

2- Install placard and label as per dwg

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

S 10/04/06

to Rev A Dwg

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Identify as per dwg & Stock, Location:

0.00

JP 10/04/06 0

Packaging

Memo

0.00

210



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/04/06 JF

POSITIVE RECALL
EFFECTIVE
RELEASED

MF 10-4-6
AUTH DATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Saturday, March 20, 2010 9:50:55 AM

Work Order ID: 57076



Parent Item: D3915-041



Parent Item Name: Light Lid ass'y, Long lid

Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2957



Rev B

Manufactured

No

100

Each

6.0000

4.0000



Mounting Plate

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

WA

Loc Qty

B57088 → *(4)*

10/04/01

6

29869

2

36399

1

56660

3

D3915-1



Prlem

Manufactured

No

100

Each

0.0000 2.0000



Rib

D4016-5



Prlem

Manufactured

No

100

Each

6.0000 3.0000



Hinge Half, Light Lid

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ENG

Loc Qty

B57089 → *(2)*

10/04/01

6

56075

6

D4019-3



Rev A

Manufactured

No

100

Each

0.0000 3.0000



Rib

D4035-045



Rev A

Manufactured

No

100

Each

0.0000 1.0000



Lid Rib Assembly, Fwd (Light)

D4036-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 2

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Work Order ID: 57076



Parent Item: D3915-041



Parent Item Name: Light Lid ass'y, Long lid

Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4035-047 	Lid Rib Assembly, Aft (Light)	Manufactured Rev A	No			100	Each	0.0000	1.0000		B56977	① 10/04/05
D4056-1 	Label Plate	Manufactured	No			100	Each	2.0000	1.0000			
D2728-1 	Dart Logo label	Manufactured	No	Main Warehouse WA 56661		180	Each	0.0000	1.0000		B56963	① 10/04/05
D4029-041 	Webbing (Long Basket)	Manufactured Rev A	No			180	Each	0.0000	1.0000		B56947	① 10/04/05
D4086-220 	Placard, Max Load	Manufactured Rev A	No			180	Each	0.0000	1.0000		B56979	① 10/04/05

Saturday, March 20, 2010 9:50:55 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Light Lid ass'y, Long lid

Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W53		Purchased		No		180	Each	758.0000	34.0000			10/10

Blind Rivet

Warehouse Loc Qty Loc Code

Location

NAS1149DN416J

Purchased

No

Washer



PTD

Sp 10/04/05

NY 13910

34

W/O: 57076		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		Change MS20600AD04-5 to MS20600AD04-3 <i>(M104107 can not change as per part list)</i> Permanent Change	EP	10/04/05	34	<i>DS</i> as per	<i>AB</i> 10/04/05	
		# Tried one AN960306 M104537 one MS20600AD04-4 M113368 OKAY to leave in basket (id)	SD	10/04/05	0	<i>AB</i> as per	<i>AB</i> 10/04/05	

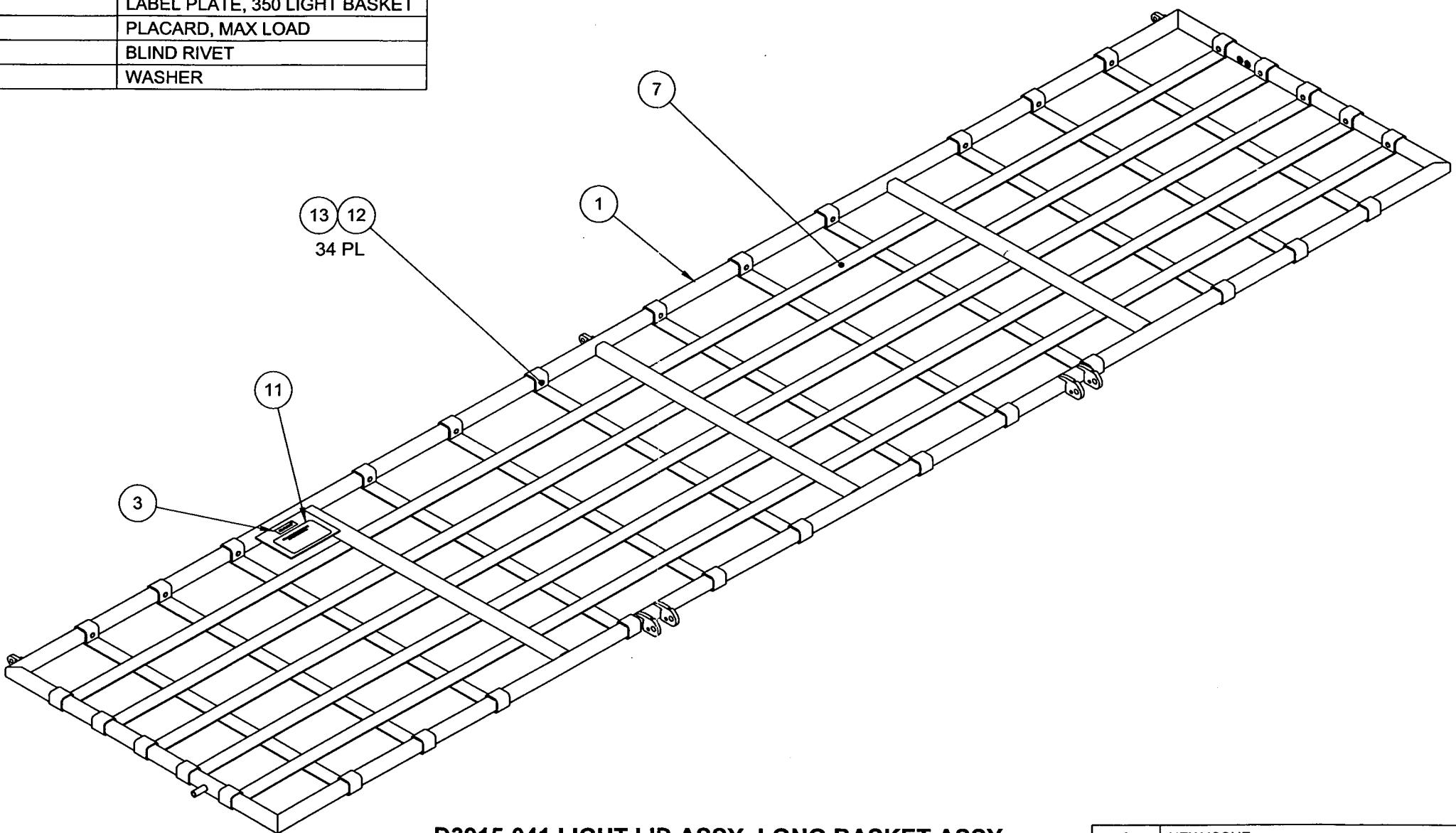
Part No: D3915-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -101	P/N	DESCRIPTION
	X		D3915-041	LIGHT LID ASSY, LONG BASKET
1	1	X	D3915-101	BASKET LID WELDMENT ASSY
2		2	D3915-1	RIB
3	1		D2728-1	DART LOGO LABEL
4		4	D2957	MOUNTING PLATE
5		3	D4016-5	HINGE HALF
6		3	D4019-3	RIB
7	1		D4029-041	WEBBING (LONG BASKET)
8		1	D4035-045	LID RIB ASSY, FWD
9		1	D4035-047	LID RIB ASSY, AFT
10		1	D4056-1	LABEL PLATE, 350 LIGHT BASKET
11	1		D4086-220	PLACARD, MAX LOAD
12	34		MS20600AD4W5	BLIND RIVET
13	34		NAS1149DN416J	WASHER



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

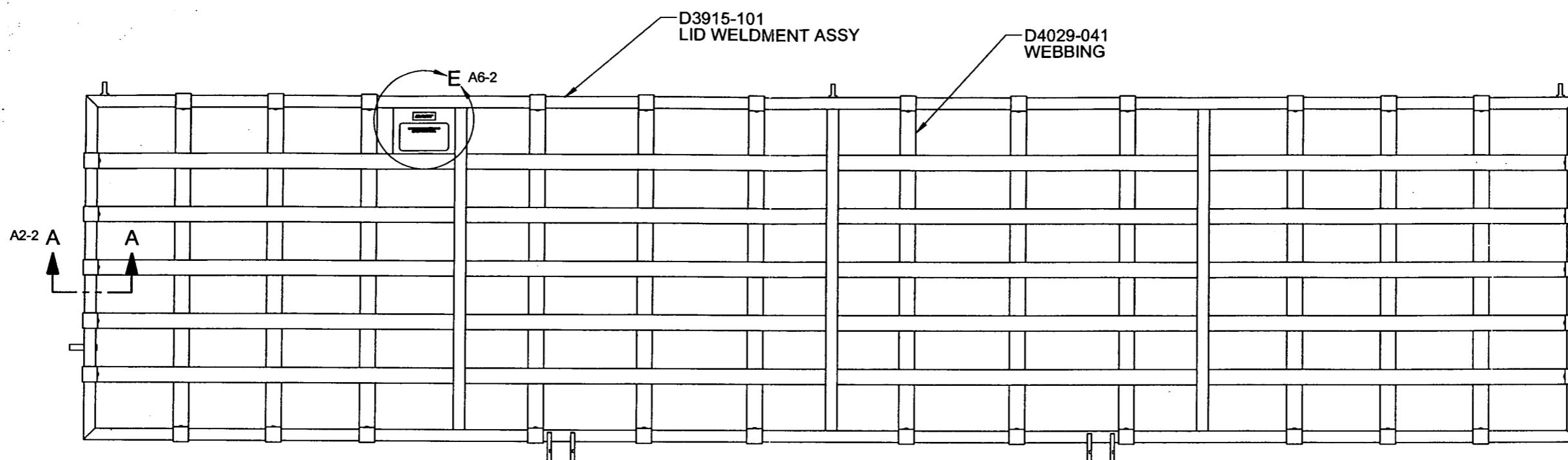
A	NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.03.16		REV. A	DRAWING NO.
			D3915	SHEET 1 OF 4
				TITLE
				SCALE
				LIGHT LID ASSY-LONG BASKET NTS
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RELEASED
2010-03-22
[Signature]

8 7 6 5 4 3 2 1

D

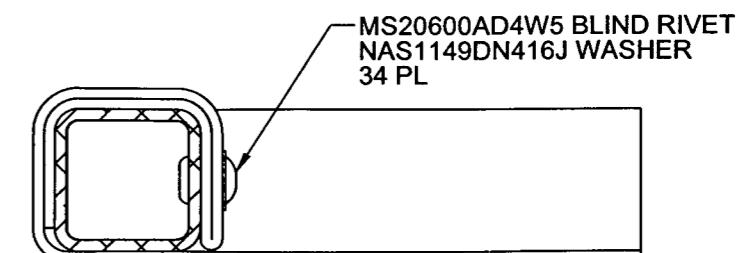
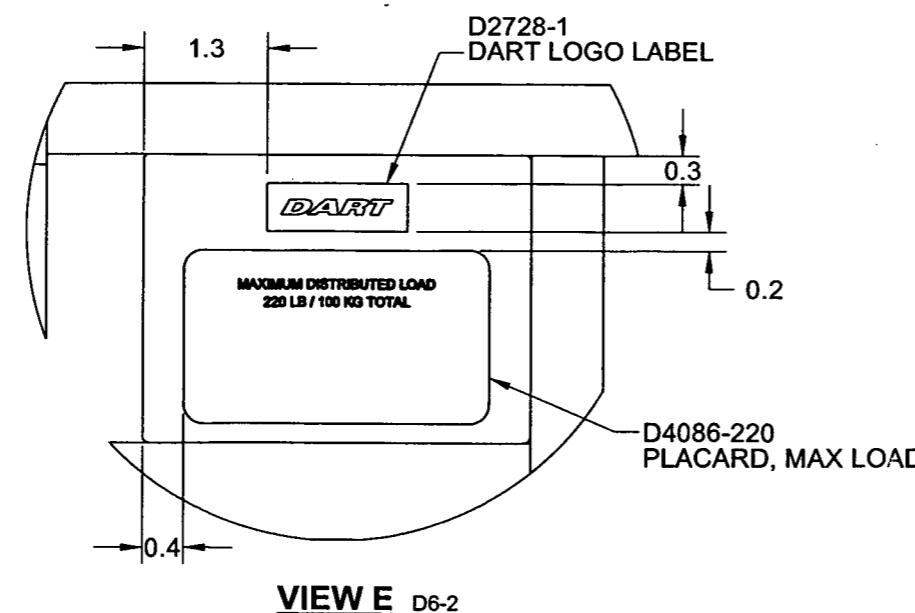
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D3915-041 LIGHT LID ASSY, LONG BASKET

B

B

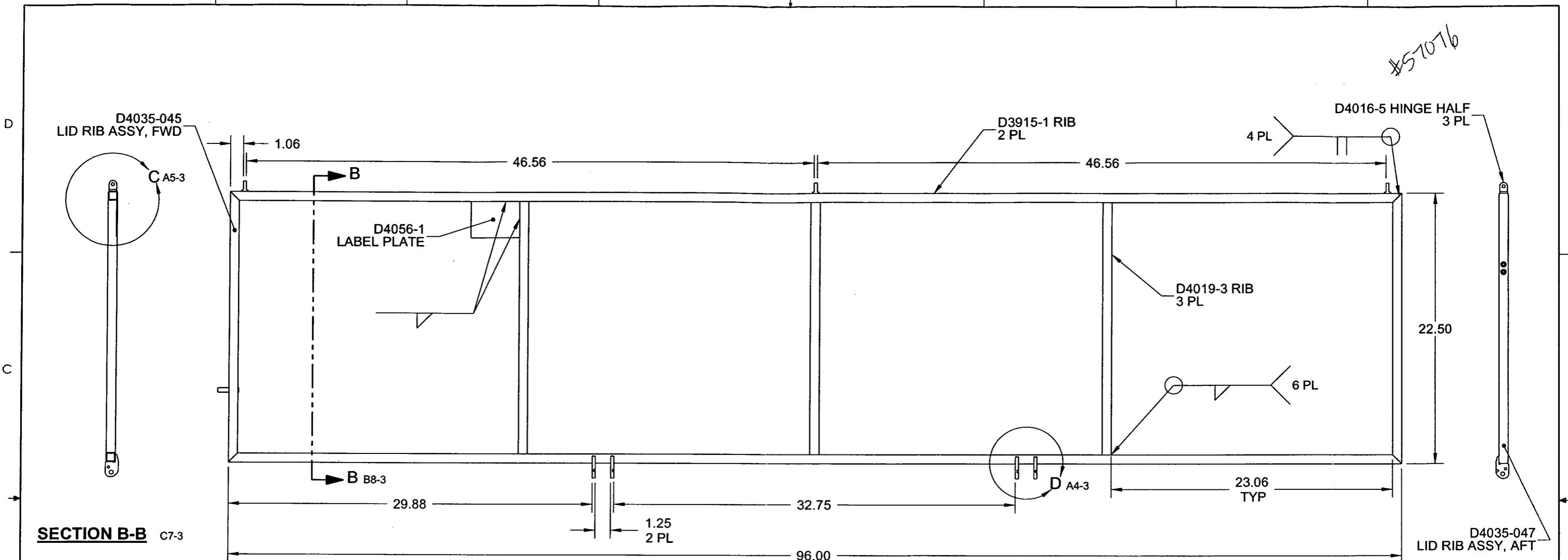


SECTION A-A C8-2

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD			
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.			
MFG. APPR.		D3915			
APPROVED		REV. A			
DE APPR.		SHEET 2 OF 4			
DATE	10.03.16	TITLE			
		SCALE			
		LIGHT LID ASSY-LONG BASKETNTS			
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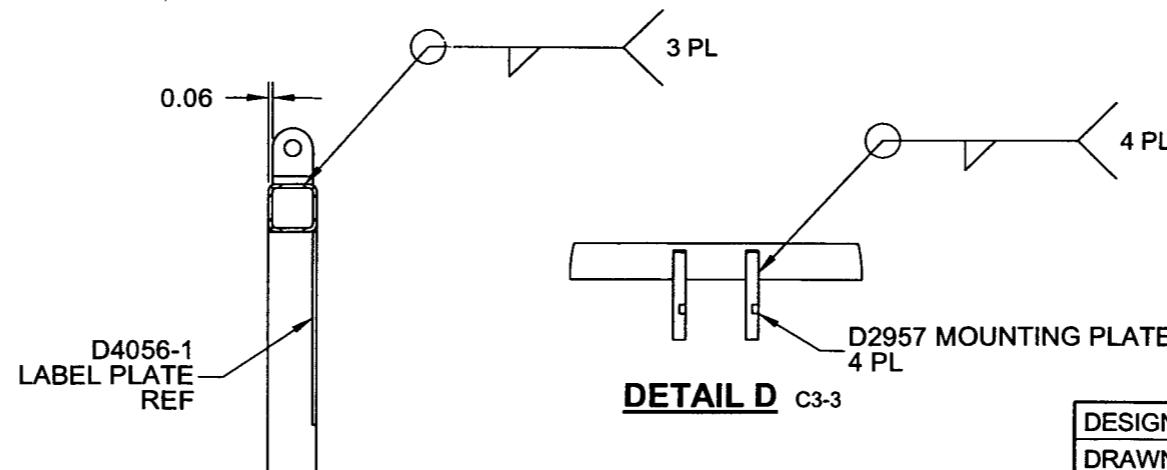
8 7 6 5 4 3 2 1



SECTION B-B C7-3

D3915-101 BASKET LID WELDMENT ASSY ASSY

#51016



DETAIL D C3-3

DETAIL C D8-3

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.81 lbs
- 8) WELD PER DART QSI 004

RELEASED
2010-03-22
VMD

DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.03.16	
DRAWING NO.	D3915	

REV. A
SHEET 3 OF 4
TITLE
SCALE
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